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D5732-1

Job Sheet 204841



Part No: D5732-1

Job Qty: 4 pcs

DAS
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9-08

Part Name: Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/20/19

Job Tracking No:

Due Date: 2/24/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: D5732 REV.A IPP REV.A NEW ISSUE JFS 19/07/16 VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	4 pcs	2/24/20	2/24/20	0.17	2.00	Waterjet - Flow	2020/01/06
							Waterjet - Omax	
110	HAAS 4 Axis - B4B	4 pcs	2/24/20	2/24/20	1.00	10.00	HAAS - 1 - B4B	1111 2020/01/19
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	4 pcs	2/24/20	2/24/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	mu 2020/01/14
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130	QC 8	4 pcs	2/24/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
140	Packaging 3-1 - Stock - B4B	4 pcs	2/24/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B

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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	4 pcs	2/24/20	0.00 0.00	QC 21 - SA - 21	DAG 21
				QC 21 - SA - 70	2-00
				QC 21 - SA - 53	
Part Op 100 - Cut blank as per D5732-1 waterjet blank. Descriptions: 110 - 1-Inspect material for defects or damage prior to machining. 2-Machine as per Folio FC891 and Dwg. 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Identify as per dwg & Stock Location: _____ 150 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	32 sf (8 ea)	100-Waterjet - Omax - 1	5235828	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	MUHMWB10	32	669	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	204841
Description: Bearpaw		Part Number:	D5732-1
Inspection Dwg: D5732	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.500	+/-0.030	36.500			Eye	
5.500	+/-0.030	5.503			vern	mm/L-05
24.00	+/-0.030	24.00			tape	
10.24	+/-0.030	10.242			Height G	300 G
2.76	+/-0.030	2.76			vern	mm/L-05
5.00	+/-0.030	4.999			"	
2.09	+/-0.030	2.085			"	
6.000	+/-0.010	5.998			"	
4.688	+/-0.010	4.685			"	
0.864	+/-0.010	.867			"	
0.915	+/-0.010	.912			"	
0.300	+/-0.010	.305			"	
0.806	+/-0.010	.810			"	
0.800	+/-0.010	.799			"	
0.400	+/-0.010	.405			"	
Ø0.261	+0.008/-0.001	.261			"	
6.400	+/-0.030	6.396			"	
3.52	+/-0.030	3.518			"	
0.950	+/-0.030	.961			"	
0.740	+/-0.030	.748			"	
0.500	+/-0.030	.568			"	
0.460	+/-0.030	.470			"	
0.700	+/-0.030	.706			"	
0.240	+/-0.030	.243			"	
0.300 x 45°	+/-0.010 x 0.5°	.300 x 45			"	
0.060 x 45°	+/-0.010 x 0.5°	.057 x 4			"	
R0.250	+/-0.010	.250			RG	
R0.030	+/-0.010	.030			RG	
0.380	+/-0.030	.388			vern	mm/L-05

Measured by:	mm/L-05	Checked by:	mm/L-05	QC Inspector:	
Date:	20/01/13	Date:	20/01/15	Date:	

Engineering Approval: (if necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	19.10.17	New Issue	MG	mm/L-05

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Job: _____ Part No. _____	MRB (QS1042)		
Date: _____	Sequence #: _____	QTY Affected: _____	Disposition
Description Work Order Deviation			
Completed By			
Lead hand / Supervisor			
QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____	
Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	